

Work Order ID 64908

Page 1

Wednesday, December 22, 2010 2:57:53 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *10/22/22* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*8 11/01/10**CL 11/01/10*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *MID 8436*
11/3928

3-Grind End Plate flush

11.01.05
*11.01.05**5*
10 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 0 3211/06

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8110107

XJ
RX

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=7 1110110

5RH

W/O:		WORK ORDER CHANGES					
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Required Date: 1/24/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

11.01.11

5

0



QC

Memo

0.00

Quality Control

180

Large Fab

0.00

5

0



Large Fab

Memo

0.00

11.01.11

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod M102436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 0 2E11/01/12

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulalvz

x5 RN

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5P+1 11-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/35P SD

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/14

x5 RH

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

NMB

Carpenter (5)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17

U 11-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 1



Required Date: 1/24/2011

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D
fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	5			
Step													
D3067-1 		Manufactured	No			110	Each	116.0000	1	5			
End Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				116					
				60141				2					
				62664				6					
				<u>63550</u>				108		<u>5</u>			
D3219-1 		Manufactured	No			110	Each	113.0000	2	10			
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				113					
				<u>63551</u>				113		<u>10</u>			
D3066-1 		Manufactured	No			180	Each	86.0000	2	10			
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				86					
				<u>63549</u>				86		<u>10</u>			

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, December 22, 2010 2:57:57 PM

Work Order ID: 64908

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

2,351.000

16

80



Rivets



11.01.11

Location

Loc Qty

Loc Code

ST321

2351

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

80

D3065-041

Manufactured

No

180

Each

42.0000

1

5



Step Leg Assembly Hi



11.01.11

Location

Loc Qty

Loc Code

WA

42

63324

2

63555

40

5

D3067-1

Manufactured

No

180

Each

116.0000

1

5



End Plate



11.01.11

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Work Order ID: 64908

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-35A - Purchased No

250 Each

118.0000

2 10



Bolt



M116354 11/11/10

Location

Loc Qty

Loc Code

ST353

118

116191

100

116419

18

D3235-1 Manufactured No

250 Each

61.0000

2 10



Mounting Lug



11/11/10

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041 Manufactured No

250 Each

8.0000

1 5



Support Assembly



B63553 11/11/10

Location

Loc Qty

Loc Code

ST460

8

64731

8

AN960JD416 NAS1149D0463J Purchased No

250 Each

30.0000

16 80



Washer



M116304 11/11/10

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

Wednesday, December 22, 2010 2:57:57 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

4

20



Washer



11/1/3sf 11/1/3sf

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A Purchased No

250 Each

101.0000

2

10



Bolt



11/1/3sf

Location

Loc Qty

Loc Code

ST341

101

114292

1

116191

100

D2618 Manufactured No

250 Each

36.0000

2

10



Bushing



11/1/3sf B65041 (40)

Location

Loc Qty

Loc Code

ST019

36

63548

36

D2230-3 Manufactured No

250 Each

94.0000

4

20



Lug



11/1/3sf

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

275.2930 1.2



Abraison Strip



11/13/10

Location

Loc Qty

Loc Code

ST403

275.2930421

56626

0.00004211

59920

59.293

63735

216

6

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

1,870.000 2



Nut



11/13/10

Location

Loc Qty

Loc Code

ST300

1870

114784

9

115835

957

116373

4

116391

900

10

AN4-13A

Purchased No

250 Each

274.0000 8



Bolt



11/13/10

Location

Loc Qty

Loc Code

ST357

274

116191

274

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

1,199.000

2

10



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1173

115156

5

115594

500

116104

172

116105

496

MS21042L4

Purchased

No

250

Each

4,242.000

8

40



Nut

Location

Loc Qty

Loc Code

ST300

4242

1123143

2

115589

10

115621

730

116188

3500

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

20



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *62908*

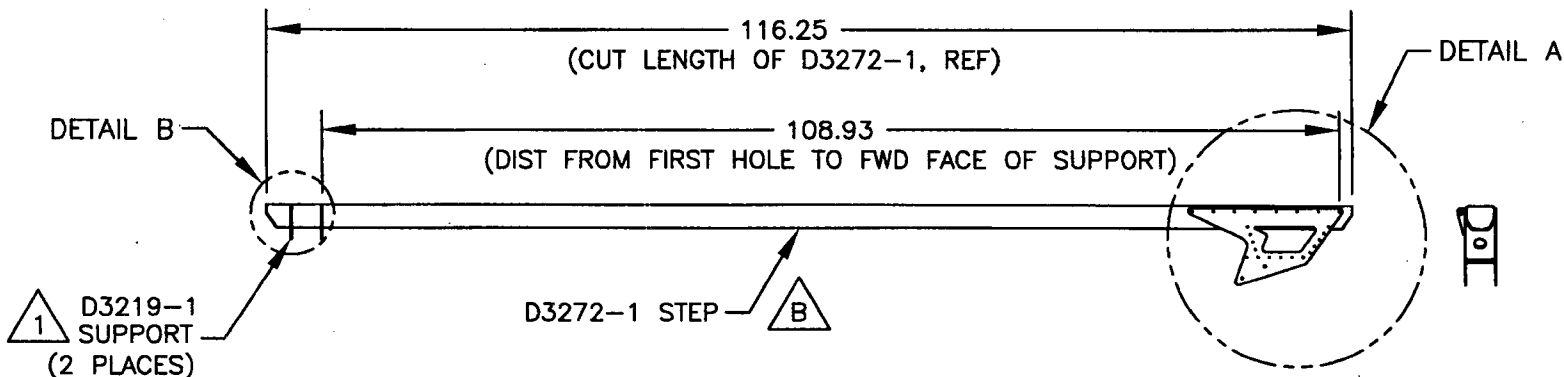
R/W D 22

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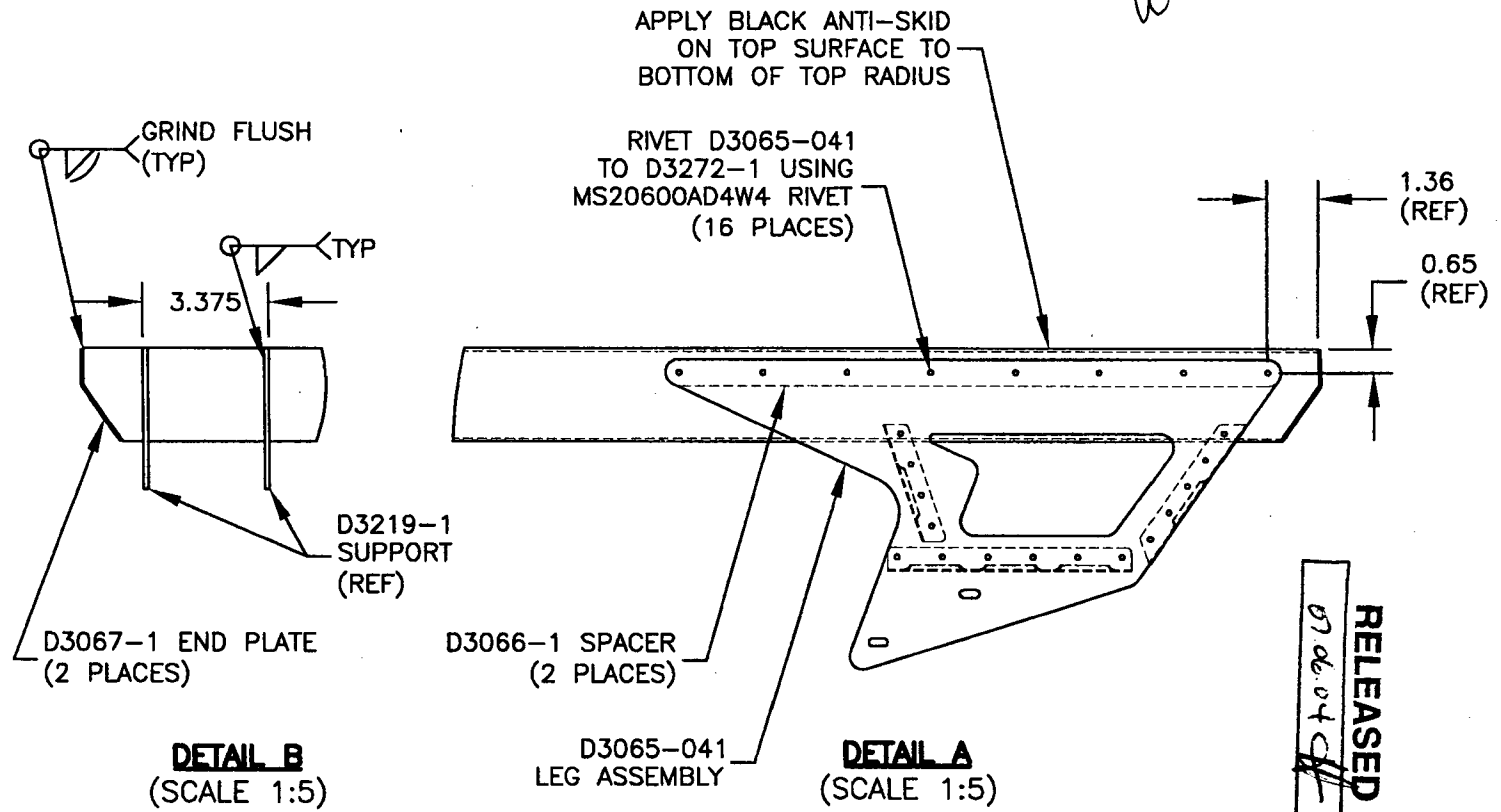
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.18	D3272	SHEET 2 OF 3
	TITLE	SCALE
	STEP ASSEMBLY, HI LONG	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



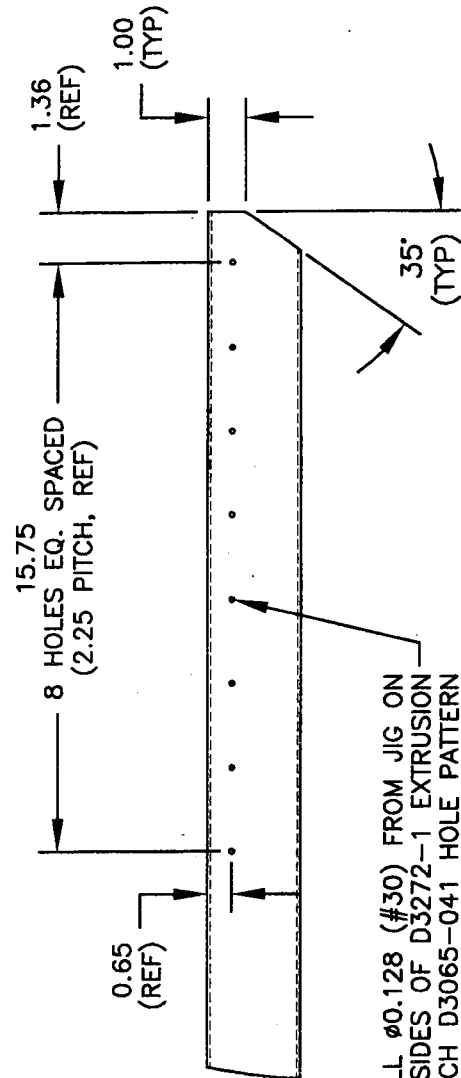
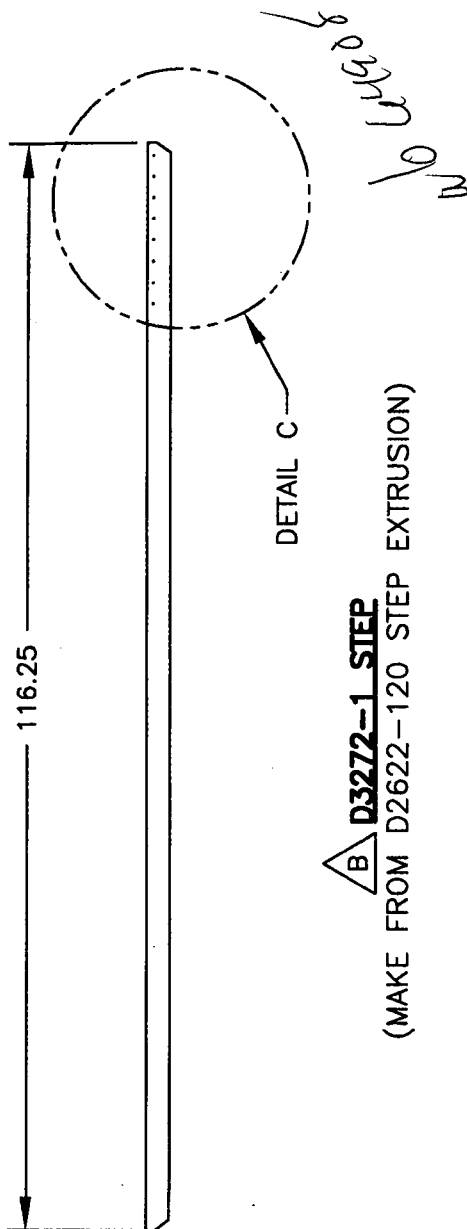
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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C
(SCALE 1:5)

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07.06.04

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REFERENCE ONLY

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D350-591
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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G
Date: 08.10.06